

# Work Order ID 76749

**\*76749\***

Page 1

Monday, November 21, 2011 10:19:28 AM

Item ID: D2661-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, LH Fwd Aft Out 206  
 Start Date: 11/21/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 1/10/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan:                      Date: 11/11/21 Tooling:                      Date:                      Run Start **\*NR1\***  
 QC:                      Date:                      SPC (Y/N):                      Date:                      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Program part number and batch number  
 MACHINE AS PER DWG AND FOLIO FB073

SL 11-12-21

FOLIO REV: AA  
 DWG REV: D

8

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11-12-21

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	SL	11-12-21		8	8		
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	ent	11/12/21		8	8		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	11/12/21	11-12-23		8	8		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 2:30								
	FINISH TIME: 3:00								
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC		0.00							
Quality Control	Memo								
170	Identify as per dwg & Stock Location 435	0.00							
<b>*170*</b>									
Packaging		0.00							
Packaging	Memo								

8X4 M-L 11/12/28

8 PR 11-12-29

11/12/2011 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 1/10/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

*ex 12/01/02*

*M.L.J 11/12/29*  
*(8)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, November 21, 2011 10:19:37 AM

Page 1

Work Order ID: 76749

**\*76749\***

Parent Item: D2661-1

**\*D2661-1\***

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house  
processEC IPP REV:D  
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003

Manufactured

No

100

Each

134.0000

1

8

\*\*

SL 11-12-20

**\*D6101-003\***

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

105

72226

8

73775

36

73780

7

74650

54

MAT44

29

72226

2

73769

1

74680

26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 76749
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2661-1
<b>Inspection Dwg:</b> D2661 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		-123	-123	-124	-123		
B	0.100	0.140		-120	-120	-120	-120		
C	1.125	1.145		1.140	1.141	1.140	1.140		
D	0.615	0.685		-680	-680	-680	-680		
E	0.240	0.260		1.244	1.244	1.245	1.245		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		-221	-221	-221	-221		
H	0.100	0.180		-140	-140	-140	-140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.581	1.582	1.580	1.581		
K	0.235	0.240		-237	-237	-237	-237		
L	0.100	0.120		-110	-110	-110	-110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		-512	-512	-512	-512		
O	5.990	6.010		5.998	5.999	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		-314	-314	-314	-314		
S	0.315	0.322		-316	-316	-316	-316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		-798	-798	-797	-797		
W	0.540	0.560		-550	-549	-550	-550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		-257	-257	-257	-257		
Z	0.912	0.932		-920	-920	-920	-920		
AA	0.490	0.510		-500	-500	-501	-499		
AB	0.178	0.198		-188	-188	-188	-188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SK
Date:	11-12-21

Audited by:	amh
Date:	11/12/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 46749
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2661-1
<b>Inspection Dwg:</b> D2661 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

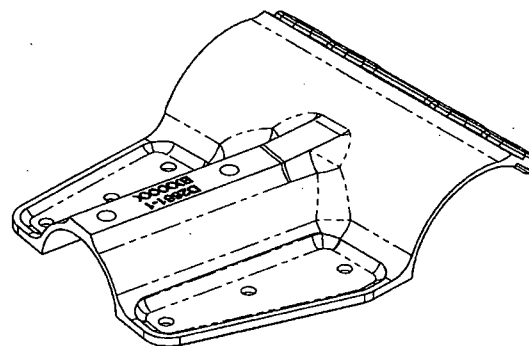
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.124	.124	.123		
B	0.100	0.140		.120	.120	.120	.120		
C	1.125	1.145		1.140	1.140	1.139	1.140		
D	0.615	0.685		.680	.680	.680	.680		
E	0.240	0.260		.246	.245	.245	.245		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		.221	.221	.221	.221		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.580	1.580	1.580	1.581		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		5.999	5.999	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.798	.797	.796		
W	0.540	0.560		.549	.549	.550	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.919	.920	.921	.922		
AA	0.490	0.510		.499	.500	.502	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 11-12-21	Date: 11/12/21

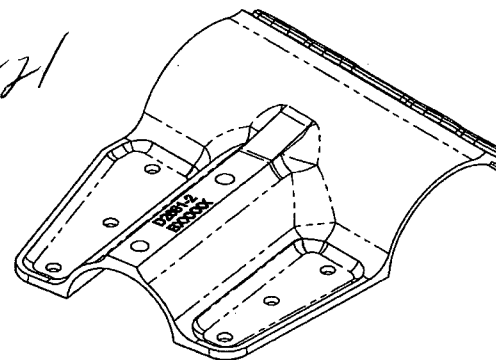
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	

SHOP COPY  
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SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK ORDER  
NO. 76-74-9

*11-11-21*



**D2661-1 SADDLE, OUTSIDE, LH**



**D2661-2 SADDLE, OUTSIDE, RH**

**RELEASED**  
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B8-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. <b>D2661</b> TITLE <b>SADDLE, OUTSIDE</b> SCALE <b>NTS</b> SHEET 1 OF 5 REV. E COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>		
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	11.10.31		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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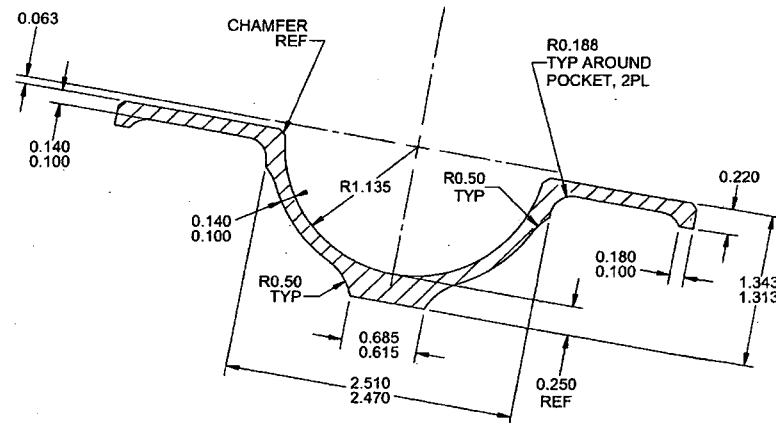
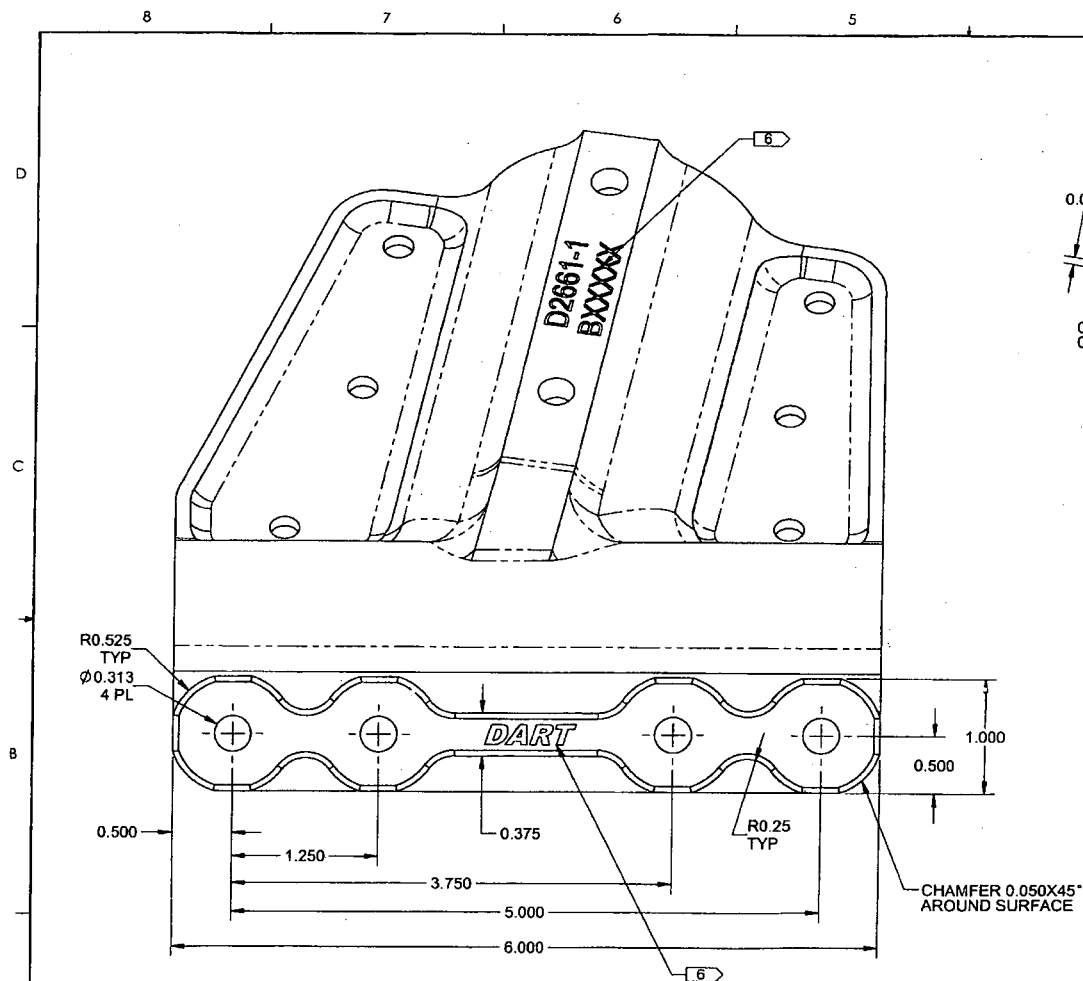
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



76749

RELEASED  
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

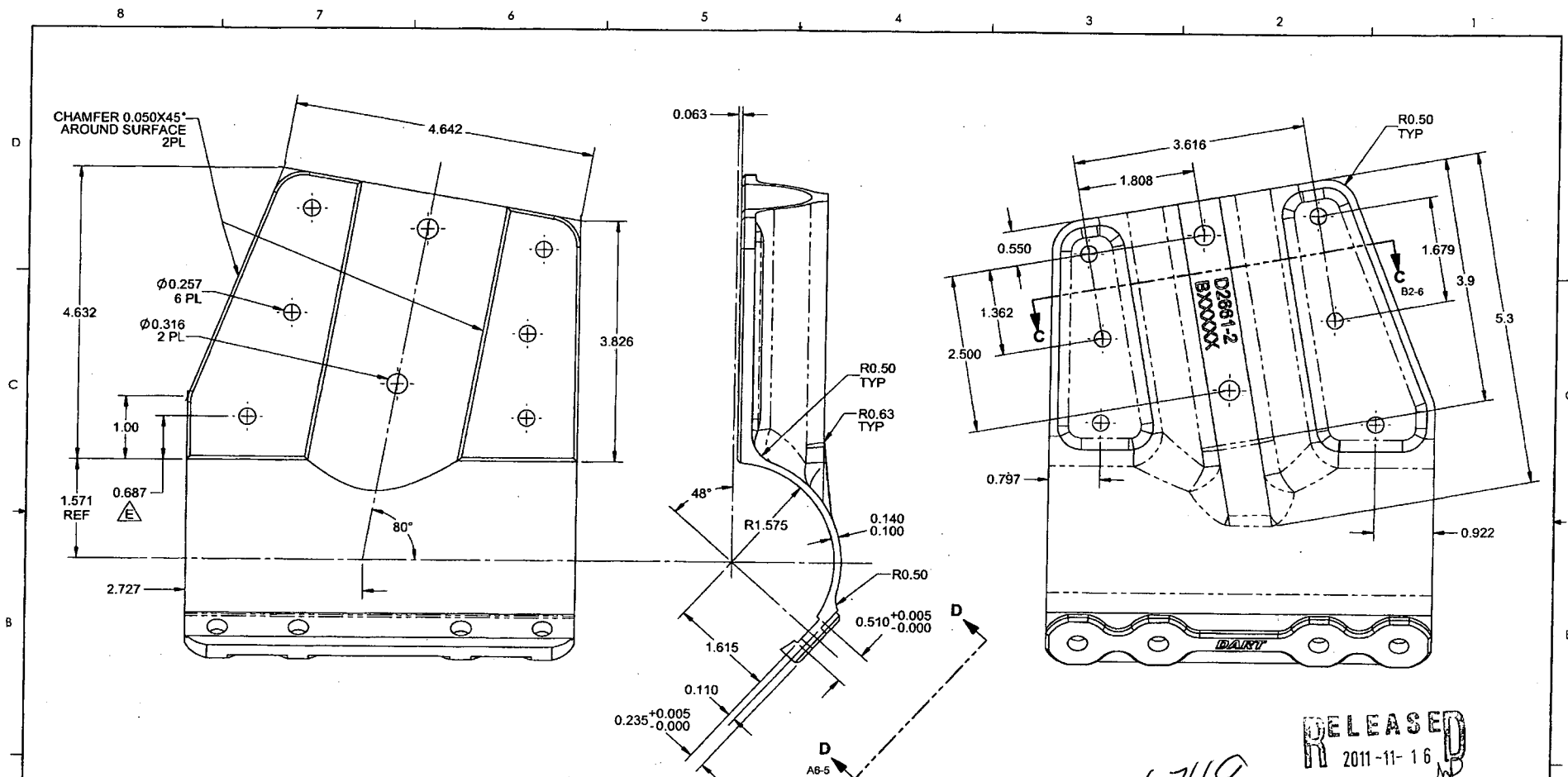
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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RELEASED  
2011-11-16

76749

# **D2661-2 SADDLE, OUTSIDE, RH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

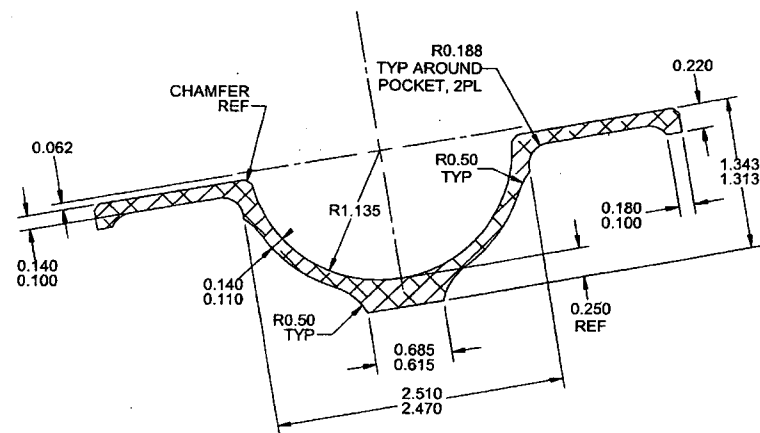
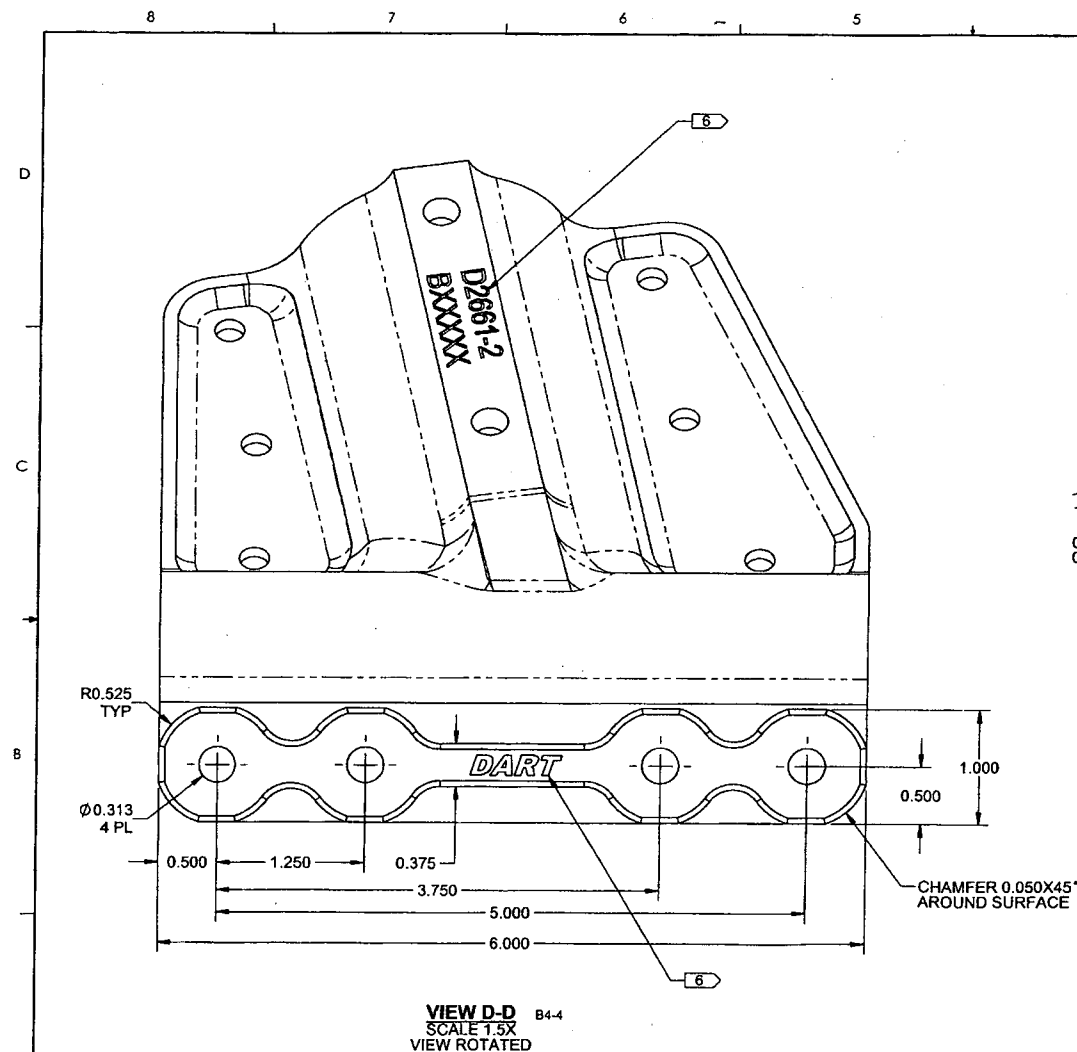
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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RELEASED  
2011-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries